

Work Order ID 129491

February-12-15 8:53:47 AM

129491

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Item ID: D2199-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut
 Start Date: 2/12/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 2/12/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference: re-paint *Rework*

Approvals: Process Plan: *V* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2199	F

130 White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel 0.00

130

Powdercoat

Powder Coating

Memo

PULL FROM TRIAL FIT:
 1 X D2199-25 B103847
 SCUFF LIGHTLY
 REPOWDER COAT PER DRWG, PER QSI005

11/29/88 8:55 400°
 START TIME:
 OVEN TEMPERATURE:
 FINISH TIME: *9:25*

1 φ 15-2-14 238

140 QC3- Inspect Part Finish 0.00

140

QC

Quality Control

Memo

0.00

1 DAS 38 28 9-89

FEB 20 2015

Work Order ID 129491***129491***

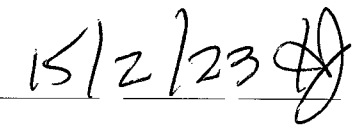
Page 2

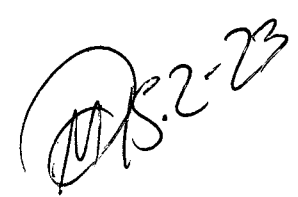
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>St 3 sa</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging	RE-IDENTIFY USING NEW B/N								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

15/2/23 

 15.2.23

Picklist Print

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Work Order ID: 129491

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Parent Item: D2199-25

D2199-25

Parent Item Name: Strut

Start Date: 2/12/15

Required Date: 2/12/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 13.03.05 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2199-25		Manufactured	No				Each	3.0000		1			
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D2199-25

Strut

13-2-19

DAS 34 9:59

Location

Loc Qty

Loc Code

Mezz

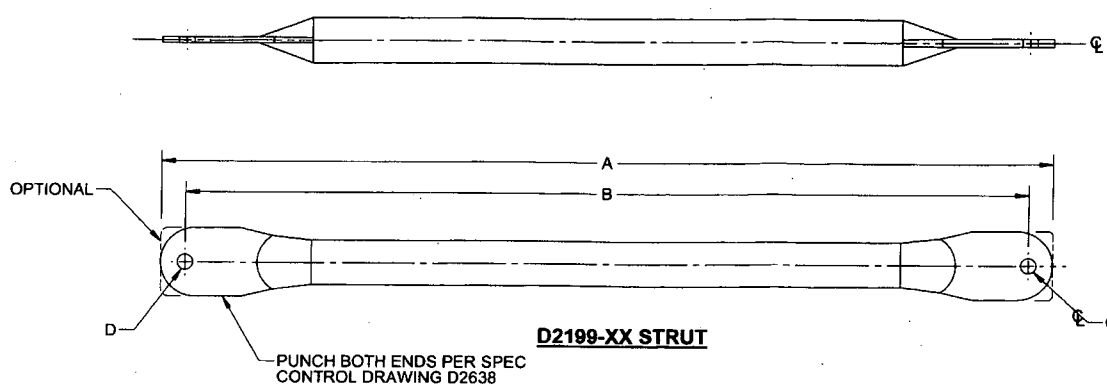
3

103102

1

103847

2



PART NUMBER	A	B	C	D	WEIGHT (LBS)	FINISH
D2199-1	18.30	17.50	Ø0.257	Ø0.257	0.56	NOTE 2
D2199-3	5.80	5.00	Ø0.257	Ø0.257	0.17	NOTE 2
D2199-5	22.64	21.84	Ø0.257	Ø0.316	0.69	NOTE 2
D2199-7	14.74	13.94	Ø0.257	Ø0.257	0.45	NOTE 2
D2199-9	16.52	15.72	Ø0.257	Ø0.257	0.50	NOTE 2
D2199-11	23.60	22.80	Ø0.257	Ø0.316	0.72	NOTE 2
D2199-13	15.96	15.16	Ø0.257	Ø0.257	0.49	NOTE 2
D2199-15	17.57	16.77	Ø0.257	Ø0.257	0.54	NOTE 2
D2199-17	28.05	27.25	Ø0.257	Ø0.316	0.86	NOTE 2
D2199-19	18.90	18.10	Ø0.257	Ø0.257	0.58	NOTE 2
D2199-21	10.80	10.00	Ø0.257	Ø0.257	0.33	NOTE 2
D2199-23	26.18	25.38	Ø0.257	Ø0.316	0.81	NOTE 2
D2199-25	19.93	19.13	Ø0.257	Ø0.257	0.61	NOTE 2
D2199-27	27.34	26.54	Ø0.257	Ø0.316	0.84	NOTE 2
D2199-29	21.11	20.31	Ø0.257	Ø0.257	0.65	NOTE 2
D2199-31	15.55	14.75	Ø0.257	Ø0.257	0.45	NOTE 3

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL ROUND TUBING Ø0.750 X 0.049 WALL PER ASTM A213 OR ASME SA213 OR ASTM A269 REF DART SPEC. M304TR0.750W0.049
- 2) FINISH: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D2199-XX" AND B/N BXXXXXX PER QSI 044, 6.5.
- 8) WEIGHT: PER CHART
- 9) MAKE PER TEMPLATE DT2199-XX WHERE XX IS THE RESPECTIVE DASH NUMBER.

RELEASED

2015 FEB 04

ECN 15-522 PS-522

F	INCORPORATED E1. REFORMATTED AND REDRAWN. ADDED -31. ADDED GREY SANDTEX FINISH.	AJS	14.09.26
E	ADDED -23 AND -25 PER TSR A56SM. ADDED TEMPLATE & SPEC CTRL. DWG REDRAWN IN CAD	KE	98.04.28
D	ADDED -21	N/A	N/A
C	ADDED -17 AND -19	N/A	N/A
B	ADDED -11, -13 AND -15	N/A	N/A
A	NEW ISSUE	JB	1993
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	DD	D2199	SHEET 1 OF 1
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT DETAILS	NTS
DATE	14.09.26	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

APPROVED